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D206-642-451
Job Sheet 184102



Part No: D206-642-451

Job Qty: 1 ea

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 10/9/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D4361-043 REV A SHEETS 1,3,4, IIN-D206-642 REV Q SHEETS 31-32 IPP REV:A NEW ISSUE 13-06-13 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/9/18	10/9/18	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs	10/9/18	10/9/18	0.00	3.70	Skid tubes-2		BB DAS
115	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC5		38 DAS
116	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC10		9-89 38
120	HandFinish	1 pcs	10/9/18	10/9/18	0.00	0.74	HandFinish1		D-R 18/10/18
130	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC7-1		BB
140	Skid tubes	1 pcs	10/9/18	10/9/18	0.00	3.70	Skid tubes-2		BB
150	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC5		BE
160	Skid tubes	1 pcs	10/9/18	10/9/18	0.00	3.70	Skid tubes-2		BE MCG
180	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC10		38 DAS
190	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC5		9-89 38
200	HandFinish	1 pcs	10/9/18	10/9/18	0.00	0.74	HandFinish2		D-R 18/10/18
210	Powdercoat	1 pcs	10/9/18	10/9/18	0.00	0.22	Powdercoat1		BE 18-10-18
220	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC3		20 38
230	HandFinish	1 pcs	10/9/18	10/9/18	0.00	0.74	HandFinish4		BE 18/10/18
240	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC5		OCT 15 2018 68
245	DC	1 pcs	10/9/18	10/9/18	0.00	0.00	DC		DAS 9-89
250	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3-1		6 OCT 16 2018
260	QC21-FG	1 Ea	10/9/18	10/9/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Deburr Fwd edge of tube 3-Weld Fwd Cap as per Dwg D4361. Use aluminum rod. Grind D2647 to fit as required. Descriptions: 5-Cut aft end to length from front of tube 6-Drill pilot holes using drill jig DT8025 & DT8169 A-B-C-D 8-Open Aft cap hole using # 6 drill bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-043 Drilling Detail

140 - 1-Open holes to finished size as per Dwg D4361, D4361-043 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D4361 (without cutting fluid) 4-Bond D2654-7 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

160 - 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. *AK 136158*

200 - Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

210 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

230 - 1-Install wearplates as per dwg D4361, 7-Wing Walk as per Dwg D4361-043 and QSI 005 4.4

245 - Photocopy bluefile and create labels per PPP D206-642-451 CHG001

250 - Identify and pack for shipping as per PPP D206-642-451

wing walk 5098120

1183983 START: 9:15 O.V.T. 320° FINISH: 9:45 Plex 10/2/18 4:12 PM dart.white.jesse

DART
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Container No: S115517



Part: D206-642-451

Job No: 184102

Serial No/Batch: S115517

Revision:

Inspector:

Exp Date:

Instructions: SH98-4 Issue 2, EASA STC SA00475SE 15/10/28, EASA STC

CAI 35
98 98-8
B0 805
98-8

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 Ea (1 ea)	90-Start up Operation	S108902
D2647	Cap	1 Ea (1 ea)	90-Start up Operation	5038805
D2654-7	Web	1 Ea (1 ea)	140-Skidtubes	5006447
D2649	Cross Bolt Spacer	26 Ea (26 ea)	160-Skidtubes	5050570
AN3-36A	Bolt	10 Ea (10 ea)	230-HandFinish	5062616
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	230-HandFinish	FM137622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	230-HandFinish	FM137886-0
D2646	Aft Cap	1 Ea (1 ea)	230-HandFinish	M163254-102
D2651-1	Plug	8 Ea (8 ea)	230-HandFinish	165327
D2651-3	O-Ring	8 Ea (8 ea)	230-HandFinish	5044502
D2680-041	Nut Plate	1 Ea (1 ea)	230-HandFinish	158428
D3873-1	Bushing	20 Ea (20 ea)	230-HandFinish	18x508877 508877 509012x5116979
D4366-041	Run-on Landing Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	508877 5159445
D4366-043	Run-on Landing Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5159452
MS21042-3	Nut	10 Ea (10 ea)	230-HandFinish	5108577
MS27039-1-08	Screw	2 Ea (2 ea)	230-HandFinish	5043210
MS27039-4-06	Screw	1 Ea (1 ea)	230-HandFinish	FM137951-1
NAS1149C0332R	Washer	10 Ea (10 ea)	230-HandFinish	5071663
NAS1149D0332J	Washer	2 Ea (2 ea)	230-HandFinish	5100407-1
NAS1149D0463J	Washer	1 Ea (1 ea)	230-HandFinish	5055952

M.U. 005715

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	18	0
	D2647	1	30	0
140-Skidtubes	D2654-7	1	7	0
160-Skidtubes	D2649	26	206	0
230-HandFinish	AN3-36A	10	69	0
	CCR264SS3-3	2	316	0
	CR3212-4-03	2	192	0
	D2646	1	66	0
	D2651-1	8	248	0
	D2651-3	8	625	0
	D2680-041	1	40	0
	D3873-1	20	38	0
	D4366-041	1	2	0
	D4366-043	1	2	0
	MS21042-3	10	426	0
	MS27039-1-08	2	472	0
	MS27039-4-06	1	73	0
	NAS1149C0332R	10	4,327	0
	NAS1149D0332J	2	2,319	0
	NAS1149D0463J	1	5,745	0

Part Specifications

Specifications could not be found.

Plex 10/2/18 4:12 PM dart.white.jesse

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-180	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

NOTES:

- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

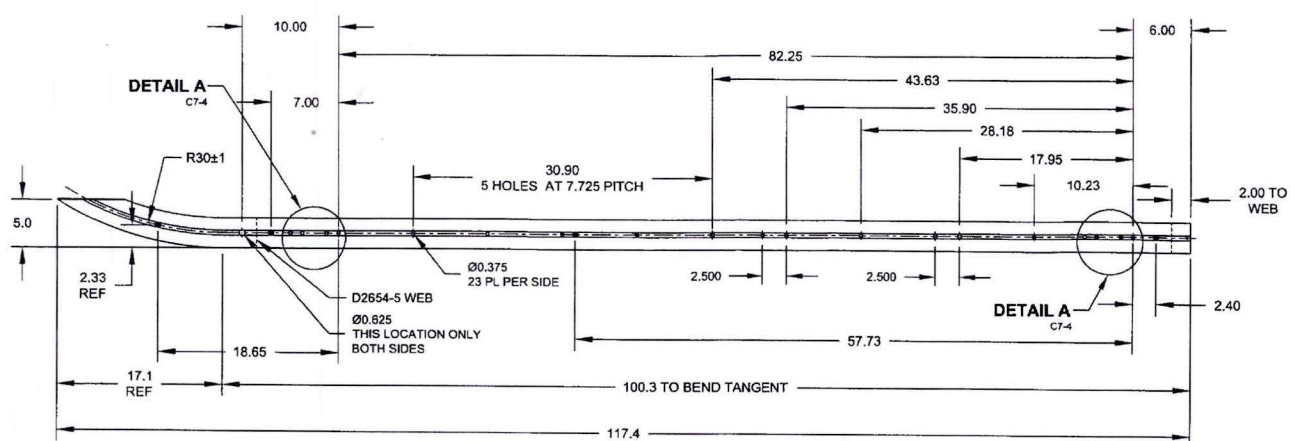
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2011-09-12

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DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	B	D4361	SHEET 1 OF 4
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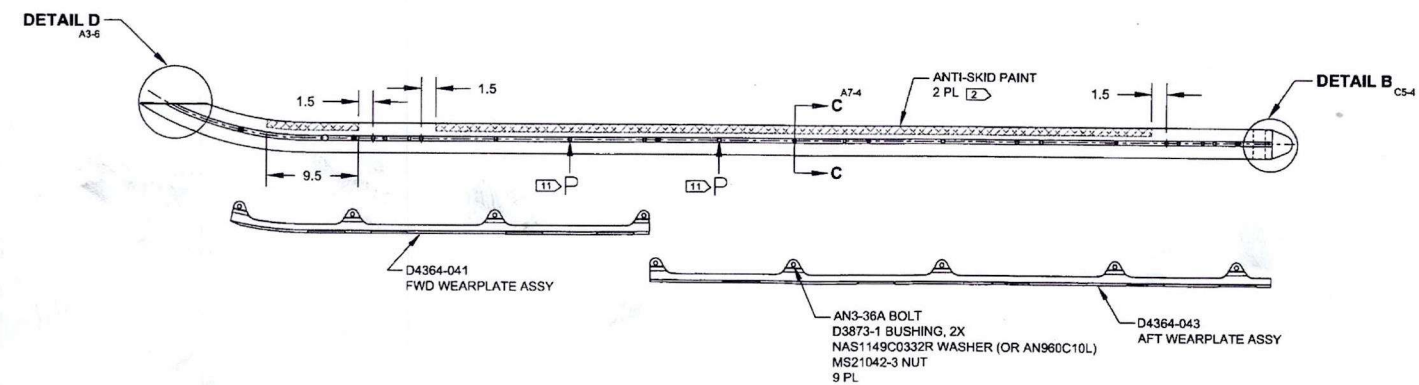
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D4361-041 BENDING/DRILLING DETAIL

B

B



D4361-041 ASSEMBLY/FINISHING DETAIL

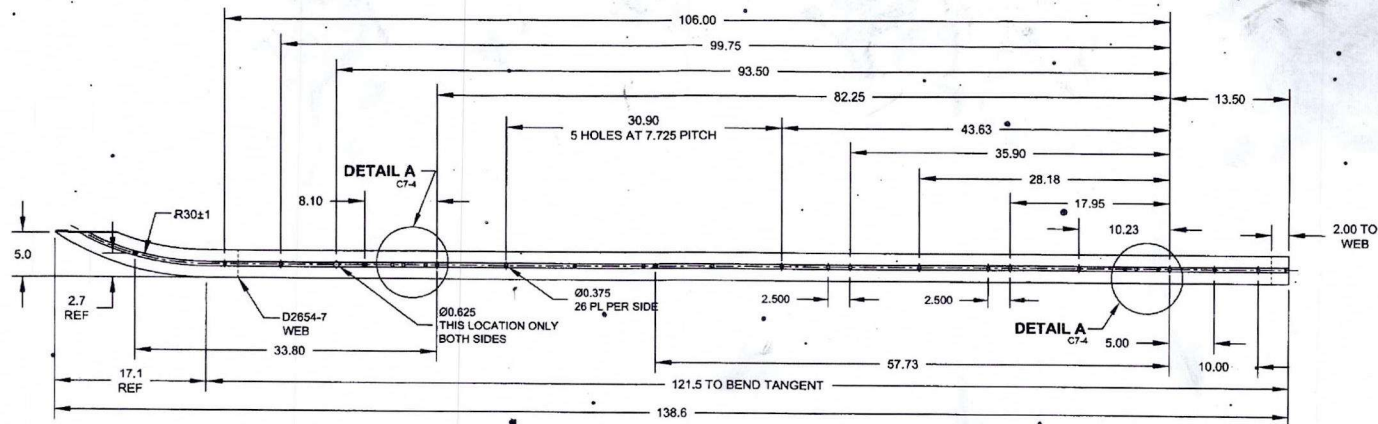
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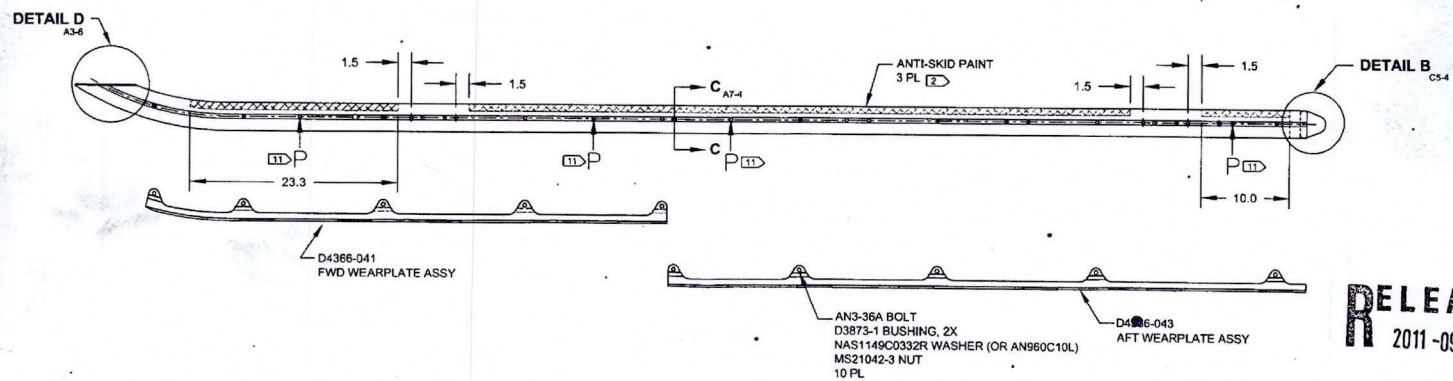
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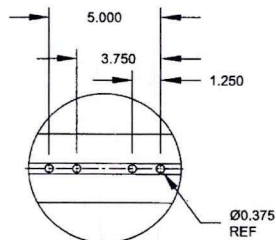
D4361-043 BENDING/DRILL DETAIL



D4361-043 ASSEMBLY/FINISHING DETAIL

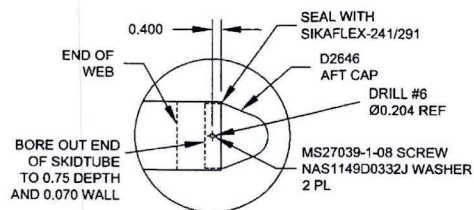
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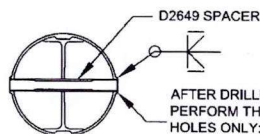
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3

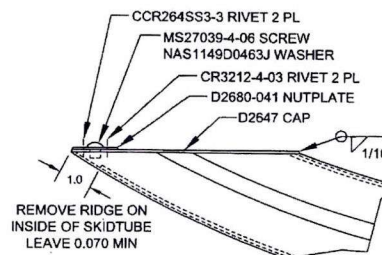
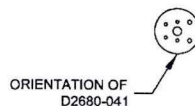


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

SECTION C-C

FOR Ø0.375 HOLES ONLY

B4-2
B5-3



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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